

Work Order ID 115123

Monday, March 17, 2014 2:46:33 PM

115123

Page 1

Item ID: D3537-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Item Name: Wearpad

Stop

NS2Start Date: 4/04/14 Start Qty: 20.00 ***20***

Cust Item ID:

Required Date: 4/04/14 Req'd Qty: 20.00 ***20***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 14-03-19
QC: _____ Date: _____Tooling: _____ Date: _____
SPC (Y/N): _____ Date: _____

Run

Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3537	Rev C	

100

100

Waterjet

FLOW CNC Waterjet

304.063

FLOW WATER JET

Memo

1-Cut as per Dwg D3537 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

110

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

0.00

0.00

24 0 Jan 14-03-31

120

120

QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

0.00

DAS
27
9-89
14/3/1324Jan 14-03-21

DQA:

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework Scrap Use-as-is Suspected Unapproved	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other			
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design Doc/Data Equip/Tooling Handling/Pre Material Operator Offset/Setup Process Supplier Training Transport Unapproved											
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function		<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence		<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled				

Work Order ID 115123

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115123

Page 2

Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 4/04/14 Start Qty: 20.00

20

Required Date: 4/04/14 Req'd Qty: 20.00

20

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center ID
130***130***

Brake NC

Operation
Description
NC BRAKESet Up/
Run Hours
0.00Tool ID
Tool #
Plan
Code
*24X*Accept
Qty
Reject
Qty
*24*Reject
Number
Insp.
Stamp
*14/04/01*DAS
36
9-89

Brake NC

Memo

Deburr if necessaryForm on Brake as per Dwg D3537 using Jigs DT8261 and DT8326. Identify as D3537-3Form Joggle as per Dwg D3537 on brake using Jig DT8158

140

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

*SJF
M/4/15**24*

150

150

Large Fab

Large Fab

Large Fab

MemoQty Description Batch A/R 2059B Hardcoat
M125226 Weld hardcoat as per Dwg D3437

0.00

0.00

*24**14/04/08**JBL*

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

Work Order: _____	DISPOSITION			AGAINST DEPARTMENT/PROCESS																	
Part No. _____	Rework <input type="checkbox"/>	Scrap <input type="checkbox"/>	Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>														
NCR No. _____	Suspected Unapproved <input type="checkbox"/>	Machining <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Finishing <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>														
Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Supplier <input type="checkbox"/>	Other <input type="checkbox"/>																	
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector												
Design																					
Doc/Data																					
Equip/Tooling																					
Handling/Pre																					
Material																					
Operator																					
Offset/Setup																					
Process																					
Supplier																					
Training																					
Transport																					
Unapproved																					
FAULT CATEGORY																					
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function						<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence				<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <hr/> <hr/> <hr/>							

Work Order ID 115123

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115123

Page 3

Item ID: D3537-3

Revision ID:

Item Name: Wearpad

Start Date: 4/04/14 Start Qty: 20.00

20

Required Date: 4/04/14 Req'd Qty: 20.00

20

Reference:

Approvals: Process Plan: _____ Date: _____

QC: _____ Date: _____

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
Description

160

QC10- Inspect visual per QSI004- ground welds

160

QC

Quality Control

Tooling: _____ Date: _____

SPC (Y/N): _____ Date: _____

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

DAS

9

9-89

(24)

1404.09

170

QC5- Inspect part completeness to step on W/O

170

QC

Quality Control

0.00

0.00

DAS

9

9-89

180

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

180

Powdercoat

Powder Coating

0.00

0.00

OVEN TEMPERATURE:

4.00

24 ♂ 144-10.

DAS
34
9-89START TIME: 3:30
FINISH TIME: 3:30

DQA: _____ Date: _____

Date:



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Date:

Work Order update only

Work Order: _____				DISPOSITION		AGAINST DEPARTMENT/PROCESS					
				Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/>	Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/>	Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/>	Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/>			
Part No. _____											
NCR No. _____											
Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Design											
Doc/Data											
Equip/Tooling											
Handling/Pre											
Material											
Operator											
Offset/Setup											
Process											
Supplier											
Training											
Transport											
Unapproved											
FAULT CATEGORY											
Landing Gear			General								
Bending	Bend		Folio/Program		Outside Dimensions		Pressure/Forced				
Centre Not Concentric	BOM/Route		Grain		Over/Under tolerance		Set-up				
Cracks	Broken/Damage/Defect		Hardware		Part Incorrect		Temperature/Cure				
Crimp/Kink/Ripple/Wave	Burrs		Inspection Incomplete/Unqualified		Part Lost/Missing		Weld				
Cuffs	Contamination		Instructions Incomplete/Unclear		Part Moved		Wrong Stock Pulled				
Crushing	Countersink		Misaligned/off center		Positioned Wrong						
Heat Treat	Cut Too Short		Mislabeled		Power Loss/Surge						
Inspection Strip in Tube	Drawing		Misread								
Marks/Chatter	Drill Holes		Off-set								
Turning Sequence	Finish		Out of Calibration								
Wave/Twist in Tube	Fit/Function		Out of Sequence								

Work Order ID 115123

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115123

Page 4

Item ID: D3537-3

Accept

N900040100

Setup

Start

NS1

Revision ID:

Stop

NS2

Item Name: Wearpad

Start Date: 4/04/14 Start Qty: 20.00 ***20***

Cust Item ID:

Required Date: 4/04/14 Req'd Qty: 20.00 ***20***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling: _____ Date: _____

Run

Start

NR1

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop

NR2Sequence ID/
Work Center ID
190
190
QCOperation
Description
QC3- Inspect Part Finish

Quality Control

200
200
Packaging

Packaging

Identify as per dwg & Stock Location: FP.00210
210
QC

Quality Control

QC21- Final Inspection - Work Order Release

Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
0.00	DAS	27					
0.00	144011	9.89					

Q4X24 C 14 04 16M2 14-04-14AD40410

DQA:

Date:



WORK ORDER NON-COMPLIANCE / UPDATE

QA Closed:

Date:

Work Order update only

Picklist Print

Page 1

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Work Order ID: 115123

115123

Parent Item: D3537-3

D3537-3

Parent Item Name: Wearpad

Start Date: 4/04/14

Required Date: 4/04/14

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No			100	sf	274.8270	0.149	4	**	JM14-03-31	

M304S16GA

304/316 Sheet .063

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT020	274.827	
M126915	1.487	
M127821	126.13	
M128054	34.04	
M128423	113.17	128423

DQA:

Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only

<p>Work Order: _____</p> <p>Part No. _____</p> <p>NCR No. _____</p>	DISPOSITION <input type="checkbox"/> Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved	AGAINST DEPARTMENT/PROCESS <input type="checkbox"/> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> Water Jet <input type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other
---	--	---

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear	General				Fault Category				
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function	<input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence	<input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled					

DART AEROSPACE LTD	Work Order:	<u>115123</u>
Description: Wearpad	Part Number:	<u>D3537-3</u>
Inspection Dwg: D3537 Rev: C		Page 1 of 1

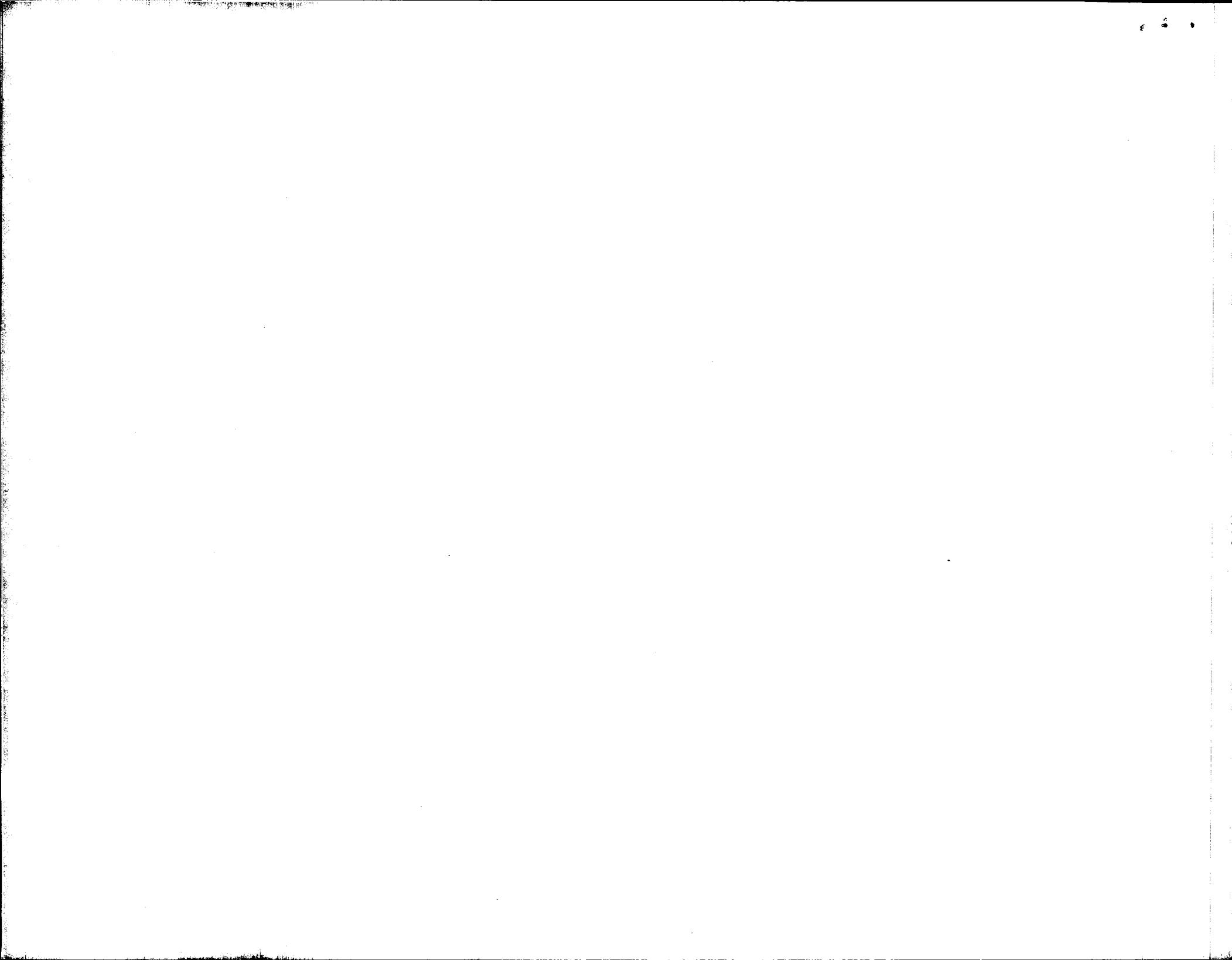
FIRST ARTICLE INSPECTION CHECKLIST

X First Article  Prototype

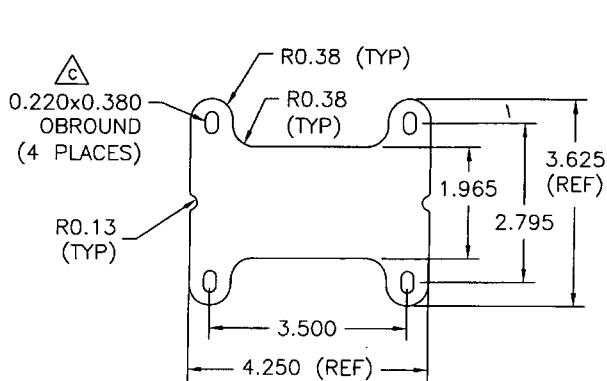
DAS

Measured by:	JM	Audited by:	27 bpd	Prototype Approval:	N/A
Date:	14-03-31	Date:	14/3/31	Date:	N/A

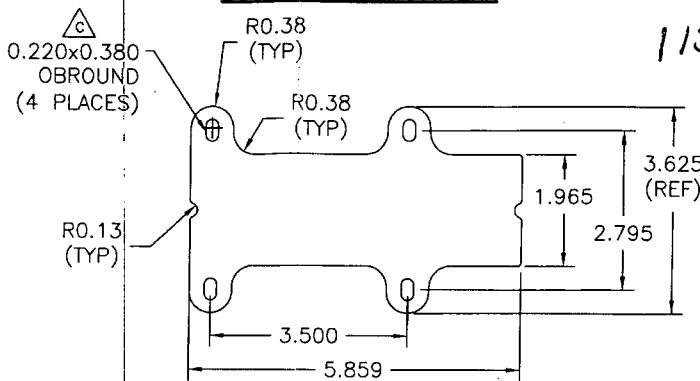
Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM <i>[Signature]</i>	<i>E</i>



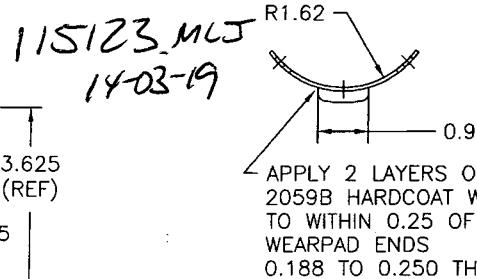
D3537-1F FLAT PATTERN



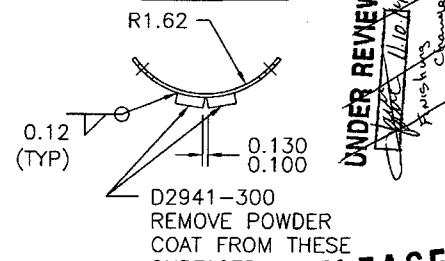
D3537-3F FLAT PATTERN



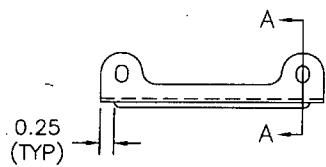
SECTION A-A



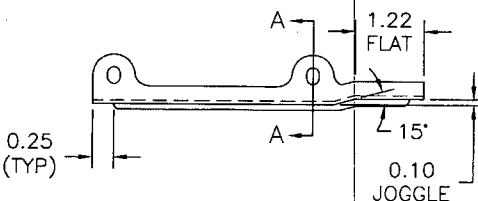
SECTION B-B



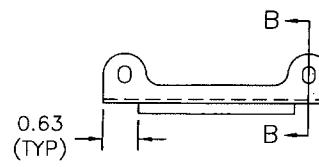
D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



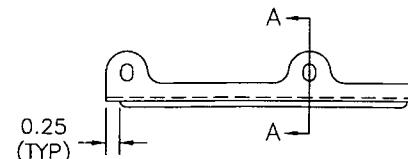
D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANTEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DART AEROSPACE USA, INC.

DESIGN	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
DRAWN BY	PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO. D3537
DATE	07.04.13	TITLE WEARPAD
		SCALE 1:2

